

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59526

June 7, 2010 9:00:56 AM



Page 2

Item ID: D2174-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 6/07/10

Start Qty: 7.00



Cust Item ID:

Required Date: 6/09/10

Req'd Qty: 7.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

Debur Stack

0.00

140

QC5- Inspect part completeness to step on W/O



0.00

QC

Memo

Quality Control

0.00

150

Chemical Conversion Coat per QSI005 4.1



0.00

HandFinish

Memo

Hand Finishing

10 BR 10-6-8.

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08

X10

0

X10

33

10/06/08

10/06/09

UMF

10-6-9

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Picklist Print

June 7, 2010 9:00:54 AM

Page 1

Work Order ID: 59526

Parent Item: D2174-1

Parent Item Name: Web

Comments: IPP ☐ C ☐ 04.06.09 ☐ Reformat ☐ KJ/RF ☐
IPP Rev:D As per Rev E 06-11-22 JLM

Start Date: 6/07/10

Required Date: 6/09/10

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	144.2000	0.4722	3.479368	4.7		



2024-T3 .063 sheet



210-6-2

Location	Loc Qty	Loc Code
MAT22	144.2	
111787	2	
113866	19.2	
114351	123	

114351

10

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DART AEROSPACE LTD		Work Order:	59526
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.250	✓			
6.400	+/-0.010	6.399	✓			
4.800	+/-0.010	4.803	✓			
1.375	+/-0.010	1.377	✓			
1.050	+/-0.005	1.051	✓			
Ø0.128	+0.005/-0.001	.131	✗			
12.650	+/-0.010	12.650	✓			
0.550	+/-0.010	.548	✓			
0.900	+/-0.010	.897	✓			
1.629	+/-0.010	1.627	✓			
1.506	+/-0.005	1.507	✓			
11.550	+/-0.005	11.552	✓			
50°	+/-0.5°	50°	✓			
0.063 thick	+/-0.010	.063	✗			
Ø0.172	+0.005/-0.001	.176	✓			

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	6-6-8	Date:	10/6/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	

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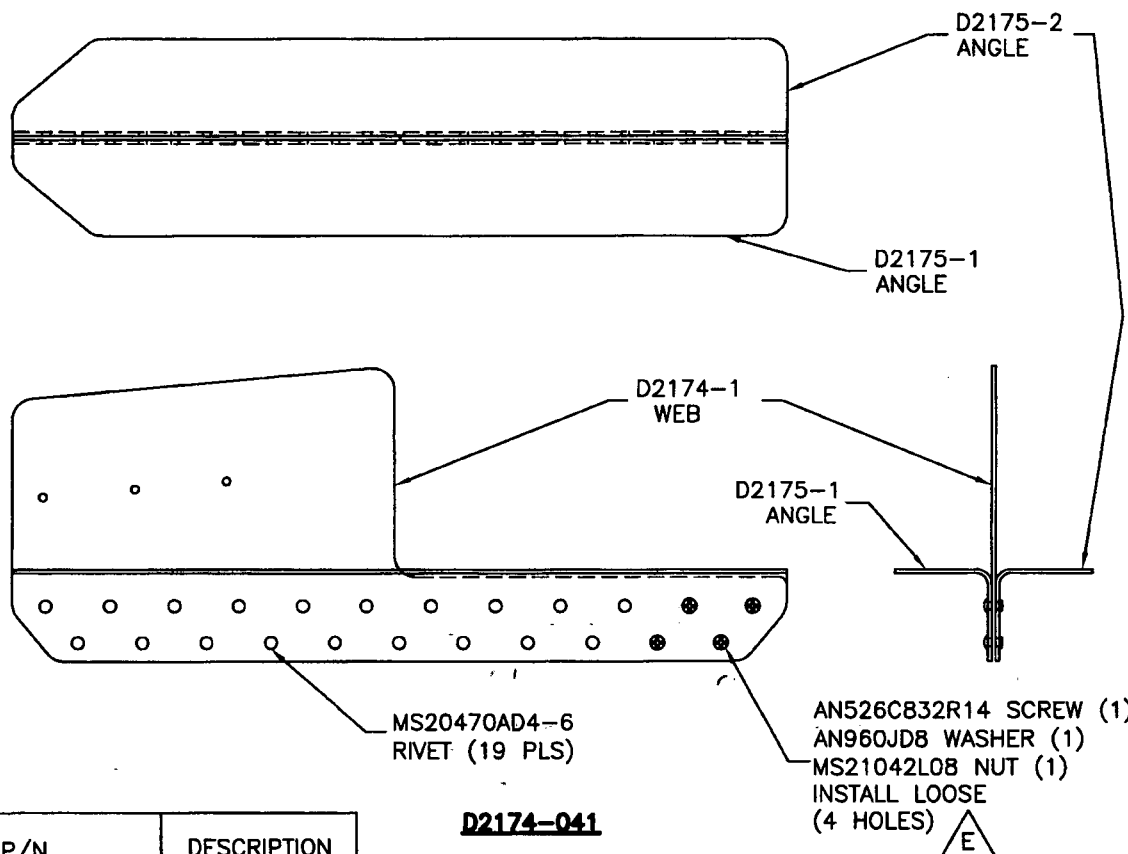
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
RF	CE	DRAWING NO.	REV. E	
CHECKED PH	APPROVED CE	D2174	SHEET 1 OF 2	
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3	
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE		

ub
59526



D2174-041

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

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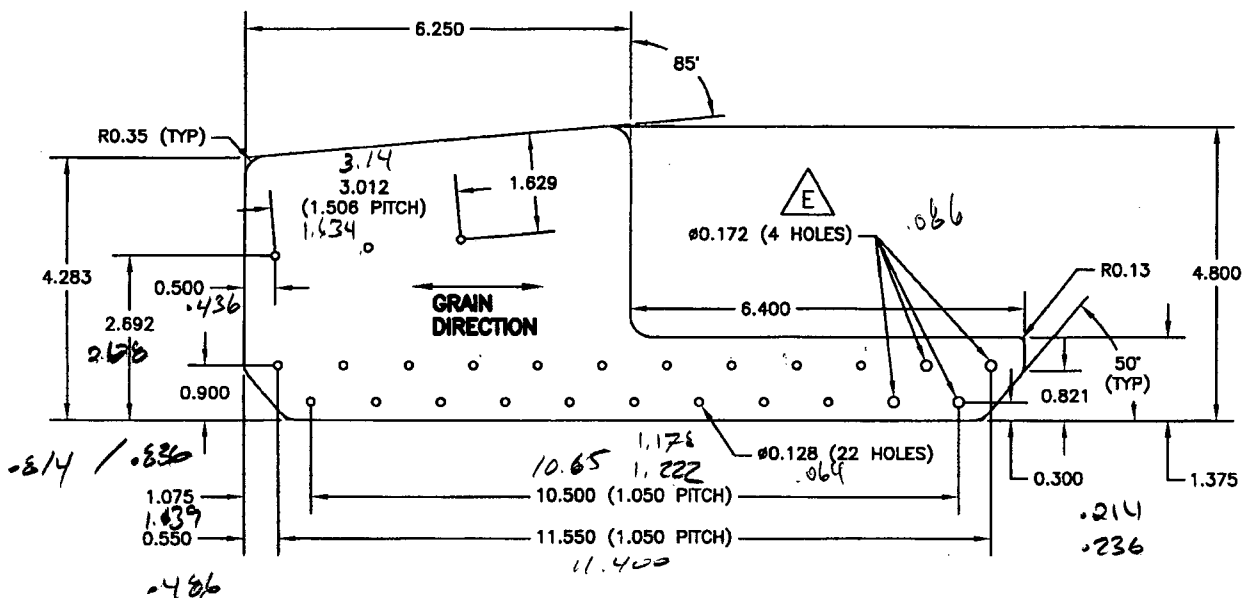
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DART

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.09.25	DRAWING NO.	D2174	REV. E
		TITLE	WEB	SHEET 2 OF 2
		SCALE	1:3	

**D2174-1****NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

RELEASED

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